

Work Order ID 57108

March 22, 2010 10:09:32 AM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 22/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 20.00



Customer:

Reference:

Jaspa 10.03.22

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

A

100



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

0.00

DR 10/03/22

20 Ø

110



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: A

DWG REV: B

DEBURR

MNF

10/03/24

20 Ø

Work Order ID 57108

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Page 2

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

I20



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*MWE
10/03/24*
20 ✓

I30



QC

Quality Control

QC8- Inspect parts - second check

0.00

10/03/27
20 ✓

I40



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

10/03/29
X20 ✓

Hand Finishing

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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

START: 7:00AM

Set Up/
Run Hours

0.00

Draw
Number

10/03/30

Draw
Rev.Plan
Code

BL

Accept
Qty

X 20

Reject
Qty

0

Reject
Number

20

Insp.
Stamp

BL

Memo TCMPS: 326°F
FIN: 7:30AM

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BL 10-3-30

(20) BL

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

BL 10/3/01

(20) BL

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Item ID: D3910-3

Accept



Setup

Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 22/03/2010 Start Qty: 20.00



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/04/06 JF

MF

10-4-5

Memo

0.00

Picklist Print

Page 1

March 22, 2010 10:09:31 AM

Work Order ID: 57108



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 22/03/2010

Required Date: 26/03/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2423 | | Manufactured | No | | | 100 | f | 566.3488 | 2.7368 | | | |

Lug Extrusion

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|-------------|----------|
| Main Warehouse | | |
| MAT | 566.3488432 | |
| 43722 | 173.462806 | |
| 44529 | 5.7731 | |
| 45800 | 387.112937 | |

2.73685 mL 10/03/20

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 57108 |
| Description: Cross tube Lug | Part Number: | D3910-3 |
| Inspection Dwg: D3910 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <i>MW</i> | Audited by: | <i>JK</i> | Prototype Approval: | N/A |
| Date: | 10/03/24 | Date: | 10/03/24 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|-----------------|
| A | | New Issue | KJ/JLM | |

8

7

6

5

4

3

2

1

D

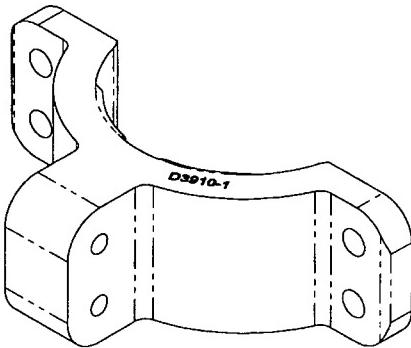
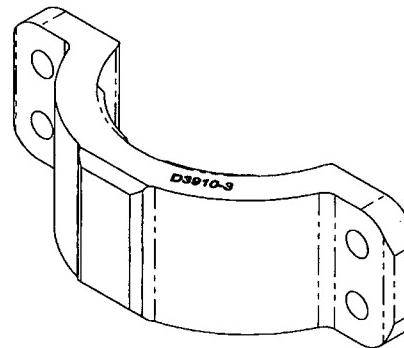
D

C

C

B

B

D3910-1 X-TUBE LUGD3910-3 X-TUBE LUGNOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

8

7

6

5

4

3

2

1

RELEASED
2010-03-22
MD

57108

| | | | | |
|----------|---|--|--------------------|------------------------|
| B | $\varnothing 0.257$ HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-607-2 | | JPH | 10.03.16 |
| A | NEW ISSUE | | JPH | 10.03.04 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | JPH | DRAWING NO. | D3910 | REV. B SHEET 1 OF 3 |
| CHECKED | JH | MFG. APPR. | <i>[Signature]</i> | APPROVED |
| DE APPR. | <i>[Signature]</i> | DATE | X-TUBE LUG (350) | SCALE NTS |
| DATE | 10.03.16 | COPRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS NOT TO BE COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |

